

Date: Monday, 11/05/2009 1:20:55 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FRAME
<b>Job Number</b> : 47844	
<b>Estimate Number</b> : 13821	
<b>P.O. Number</b> :	<b>Part Number</b> : D22529
<b>This Issue</b> : 11/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2252 REV G
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : G
<b>Previous Run</b> : 46830	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 22/05/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 09.05.11</u>	
<b>Comment</b> : Est Rev:A 09.03.18 New Issue EC verified by:DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W



**Comment:** Qty.: 0.8978 f(s)/Unit Total : 1.7955 f(s)  
 304 SQ Tube .75x.75x.065W  
 batch: M11432

SAD 09-05-20

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1- Cut as per dwg D2252  
 2- Deburr and remove identification markings on tube

SAD 09-05-20 (2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SAD 09-05-21 (42)

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and Stock  
 Location: Basket

PD 09-05-22 (2)

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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**Comment:** FINAL INSPECTION/W/O RELEASE

09/05/26

Job Completion



u 09.05.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

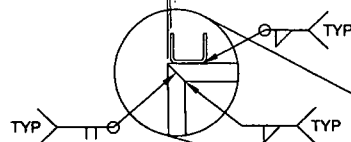
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9/10/18

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JJB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L)	NTS
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- NOTES:
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
  - 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
  - 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
  - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 6) BREAK SHARP EDGES: N/A
  - 7) IDENTIFICATION: N/A
  - 8) WEIGHT: N/A
  - 9) WELDING: PER DART QSI 004

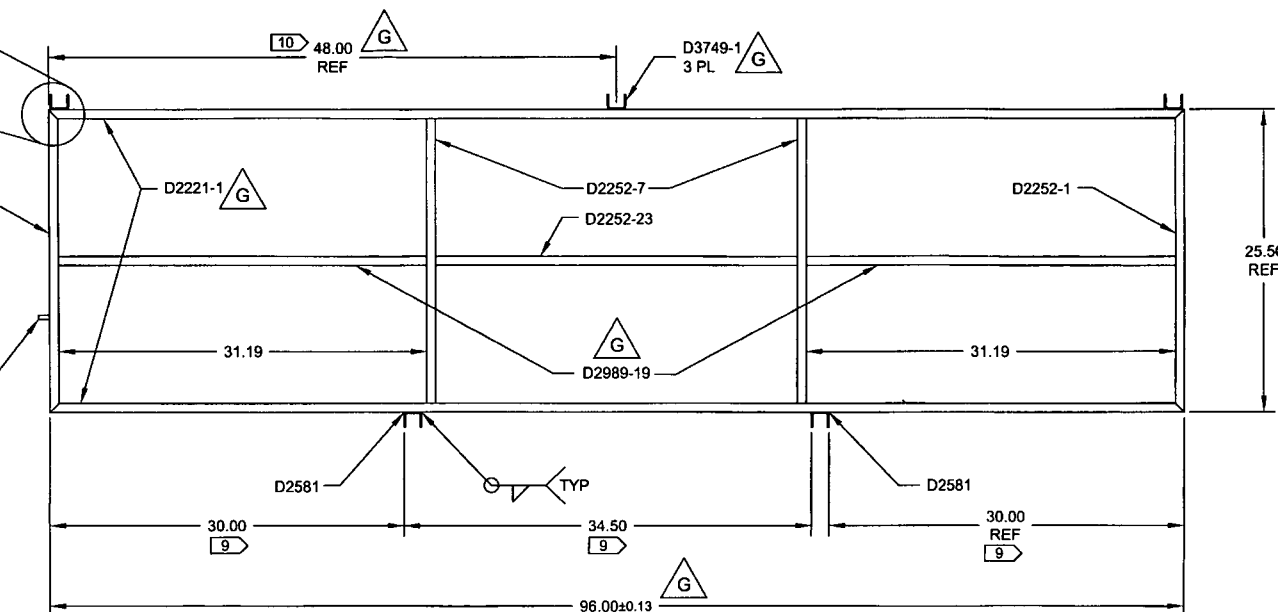
10 0.13  
2 PL, REF



WELD ALL JOINTS  
AS SHOWN

D2252-1

D2327-3  
REF  
SEE DETAIL F  
B2-5



A

A D7-5

# D2252-043 LID FRAME

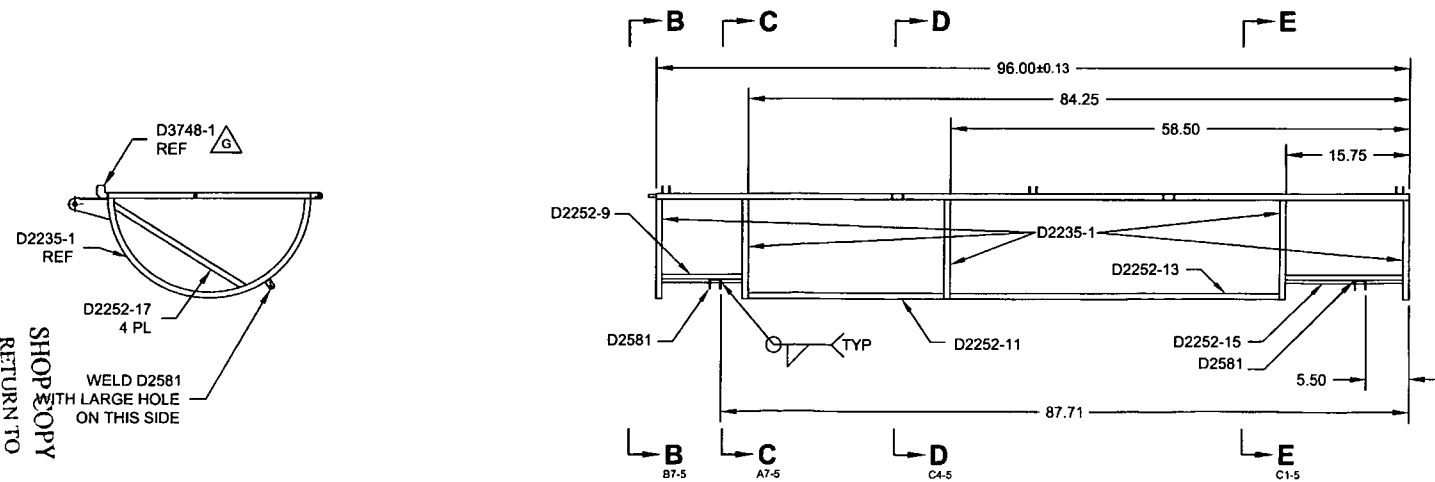
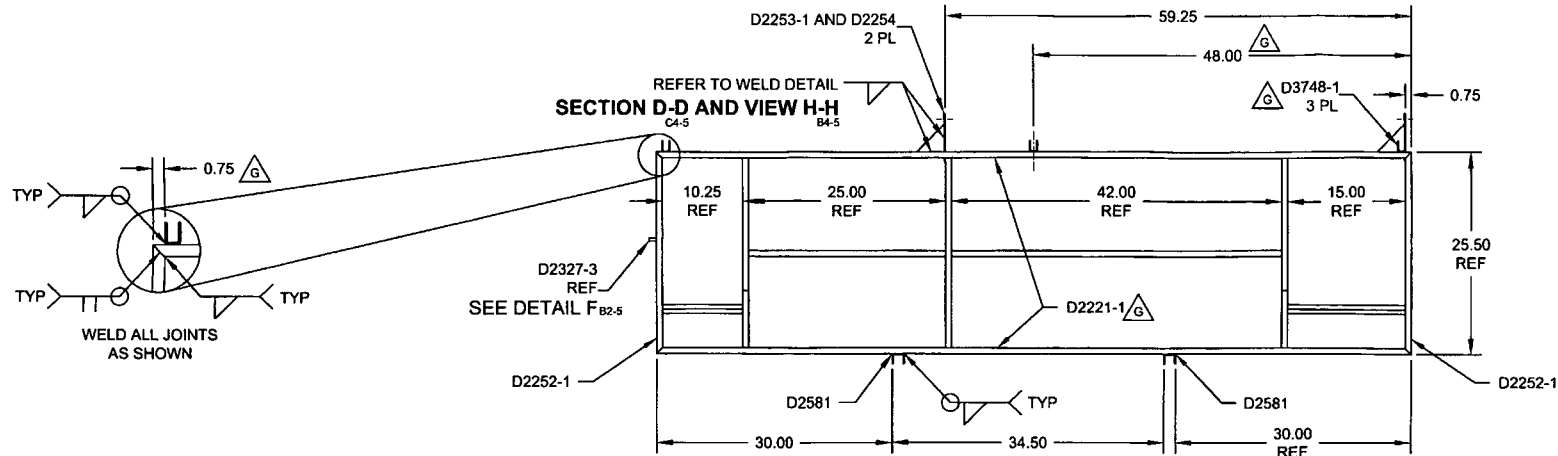
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9/2/83

## LID FRAME NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

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D2252-041 BASE FRAME ASSEMBLY

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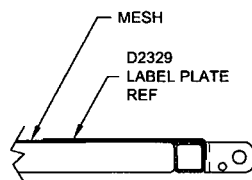
**BASE FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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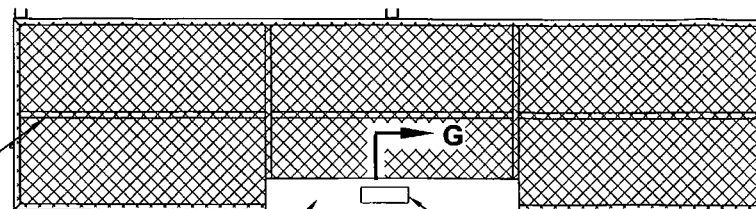
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8 7 6 5 4 3 2 1



**SECTION G-G C3-4**  
ROTATED 90° CCW

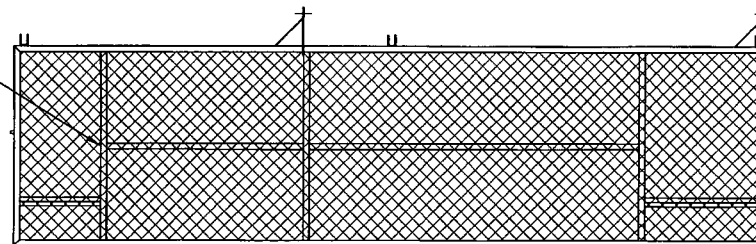
TACK WELD EACH  
STRAND END OF  
STEEL MESH TO FRAME



D2329 LABEL PLATE  
CENTER ON THE  
BASKET LID

REMOVE 2" X 6" SECTION  
OF MESH FROM BEHIND  
LABEL PLATE

**D2252-043 LID ASSEMBLY**



**D2252-041 BASE ASSEMBLY**

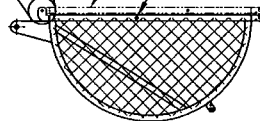
TRANSFER MARK FROM D3749-1  
HINGE HALF ON D2252-043 LID ASSY,  
DRILL Ø0.261 THRU

0.200  
PRIOR TO DRILLING Ø0.261  
HOLE THRU D3748-1 AND D3749-1

D3748-1  
3 PL. REF

D2252-043  
REF

TRIM MESH LOCALLY  
AS REQUIRED



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**ASSEMBLY NOTES:**

- 1) MATERIAL: SEE SHEET 1 FOR MESH MATERIAL
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

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8 7 6 5 4 3 2 1

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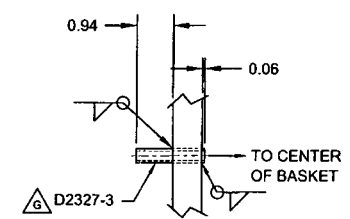
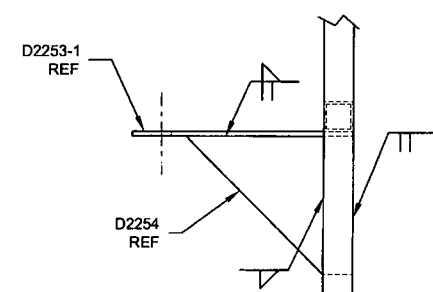
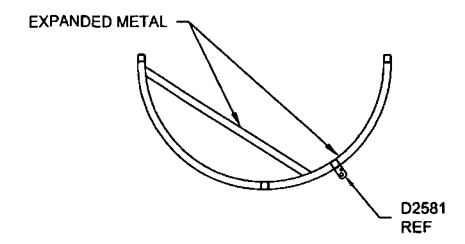
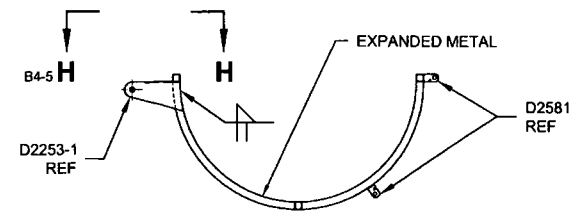
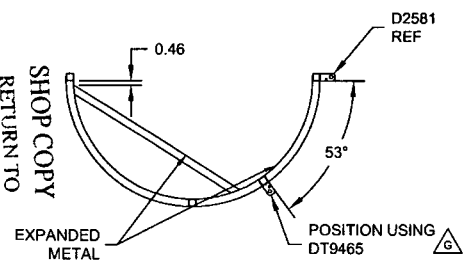
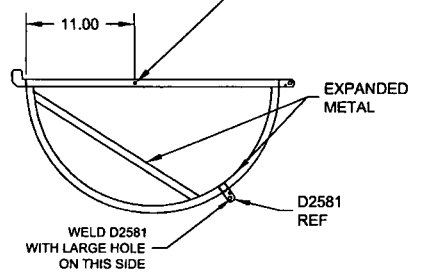
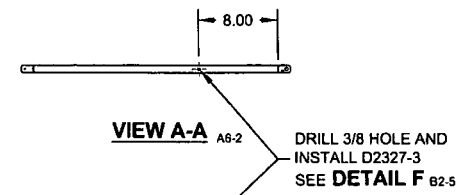
A

B

C

D

8 7 6 5 4 3 2 1



**VIEW H-H** D4-3  
D5-5

**DETAIL F** C5-3  
SPACER INSTALLATION C6-2

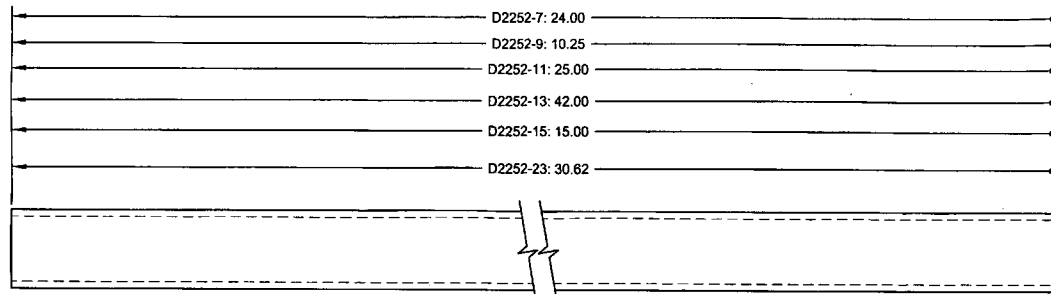
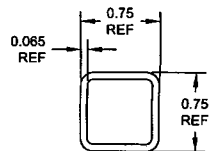
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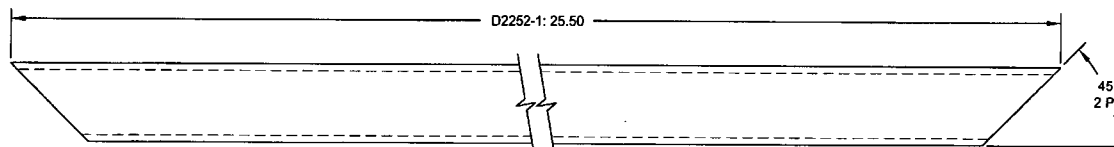
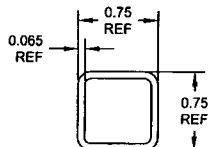
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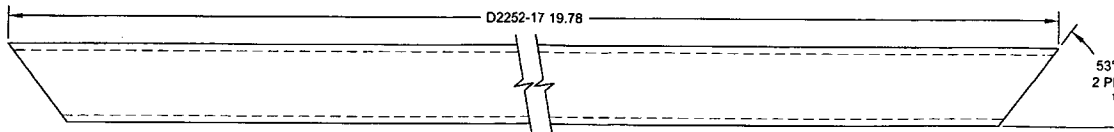
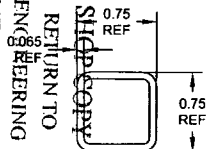
8 7 6 5 4 3 2 1



D2252-7 FRAME  
D2252-9 FRAME  
D2252-11 FRAME  
D2252-13 FRAME  
D2252-15 FRAME  
D2252-23 FRAME



D2252-1 FRAME



D2252-17 FRAME

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  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

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